Work Order ID 137070

Thursday, September 24, 2015 2:07:46 PM

137070

Item ID: D2530 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Handle Weldment

Start Date: 9/23/15 **Start Qty:** 8.00 *8*

Required Date: 9/23/15 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** SEP 25 2015 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2530	Rev B								
100		0.00							
100	Small Fab					8	FF	SEP 30 2015	
Small Fab	**Memo**	0.03							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
110						(8)			
QC	**Memo**	0.00							OCT 01 2015
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: m123823	0.00							
120	Small Fab					x8	JL	16-02-09	
Large Fab	**Memo**	0.03							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		**Disposition**	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause

Environment ☐	☐ No Re-verfication	Design ☐	☐ Operator
Doc/Data ☐	☐ Offset/Setup	Equip/Tooling ☐	☐ Supplier
Handling/Pre ☐	☐ Training	Material ☐	☐ Use for Testing
Internal Transport ☐	☐ Poor Information	Tribal Knowledge ☐	☐ Rushing
LOA ☐	☐ Product Improvement	Substation ☐	☐ Process Improvement
Past Expiry Date ☐	☐ Manufacturing Process	Misidentified ☐	☐ Past Due

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

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Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00				8	16-2-9		DAS 50 9-89
130 QC Quality Control	**Memo**	0.00							
140	QC5- Inspect part completeness to step on W/O	0.00				8	16-2-9		DAS 50 9-89
140 QC Quality Control	**Memo**	0.00							
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				8	ϕ	16-02-10.	DAS 34 9-89
150 Powdercoat Powder Coating	M129777 **Memo** START TIME: 7:50. OVEN TEMPERATURE: 320° FINISH TIME: 8:50.	0.00							

DAS 18 9-89

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Handling/Pre ☐	☐	Training	
Material ☐	☐	Use for Testing	
Internal Transport ☐	☐	Poor Information	
Tribal Knowledge ☐	☐	Rushing	
LOA ☐	☐	Product Improvement	
Substation ☐	☐	Process Improvement	
Past Expiry Date ☐	☐	Manufacturing Process	
Misidentified ☐	☐	Past Due	

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160	QC3- Inspect Part Finish	0.00				(8)			DAS 38 2-89 FEB 10 2016
160 QC Quality Control	**Memo**	0.00							
170	Identify as per dwg & Stock Location: 3379	0.00				8			DAS 6 2-89 FEB 10 2016
170 Packaging Packaging	**Memo**	0.00							
180	QC21- Final Inspection - Work Order Release	0.00				MCJ			FEB 10 2016
180 QC Quality Control	**Memo**	0.01							

MCJ FEB 10 2016

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Material ☐	☐	Use for Testing	
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Picklist Print

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Work Order ID: 137070 *137070*

Parent Item: D2530 *D2530*

Parent Item Name: Handle Weldment

Start Date: 9/23/15 **Required Date:** 9/23/15

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2534		Manufactured	No			120	Each	55.0000	2	16			
D2534 Lock Plate		B 139602 x 16							**	x16	JRE	16-02-09	

Location	Loc Qty	Loc Code	
WA004	55		
132681	55		

M304TR0.750W.049		Purchased	No			100	f	98.6988	2.9145	24.54316	FF	SEP 3 0 2015	
M304TR0.750W.049 304 RD Tube .750 x .049W									**				

Location		Loc Qty	Loc Code	
GA002		95.3776082		
	M128084	3.4736842		
	M129363	3.5		
	M130292	0.51		
	M132270	31.3059		
	M132775	8.859604		
	M133131	47.72842		24.5431
MAT		3.32121		
	M132562	3.32121		

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